

Date: Tuesday, 10/3/2006 3:47:24 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DRIVESHAFT TUNNEL MOD KIT
Job Number :	28854		
Estimate Number :	12544		
P.O. Number :	N/A	Part Number :	D412705015
This Issue :	10/3/2006	Drawing Number :	IIN D412-705 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	B
Previous Run :	N/A	Material :	N/A
Written By :	<u>[Signature]</u>	Due Date :	10/30/2006
Checked & Approved By :	<u>[Signature]</u>	Qty:	2
Comment :	Est Rev:B Removed Manufacturing 06-10-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPP D412-705-015 CHG001

KS 06 10.06

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D3256041	Access Panel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Access Panel Assembly
Batch: 1323737

4.0	AN3C3A	Bolt
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Comment: Qty.: 22.0000 Each(s)/Unit Total : 44.0000 Each(s)
Bolt M17651 22mcp M18762 22mcp

5.0	AN3C4A	BOLT
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)
BOLT
Batch: M101390

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: H Date: 06/10/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:47:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRIVESHAFT TUNNEL MOD KIT

Job Number: 28854

Part Number: D412705015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS932109

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Batch: M18575 25mcp — M17654 25mcp —

7.0

MS20427M33

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total : 88.0000 Each(s)

Rivet

Batch: M17654

8.0

MS21060L3K

Nut Plate



Comment: Qty.: 22.0000 Each(s)/Unit Total : 44.0000 Each(s)

Nut Plate

Batch: M17654 24mcp — M18575 20mcp — Rec'd 10/10/11 (2)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 06/10/11 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Identify and pack for shipping as per PPP D412-705-015

Location:

PPP Rev: B

Rec'd 10/10/11 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Rec'd 06/10/11 (2)

Job Completion



W 06/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-705-011 Twin Pak E-Z Access Kits (net)	6.3 lb 2.86 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.80 m	1190.7 in lb 13.73 m kg
D412-705-013 Intake Plenum Access Panel Kit	2.5 lb 1.16 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	175 in 4.44 m	437.5 in lb 5.15 m kg
D412-705-015 Drive Shaft Tunnel Modification Kit	1.1 lb 0.50 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.81 m	208.2 in lb 2.41 m kg
D412-705-017 N1 Gearbox Access Panel Kit (net)	1.0 lb 0.47 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	166 in 4.22 m	166.0 in lb 1.98 m kg
D412-705-019 C-Box Oil Cooler Line Support Access Kit (net)	1.2 lb 0.53 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	278.5 in lb 3.21 m kg
D412-705-021 Oil Pressure Transmitter Access Kit (net)	0.3 lb 0.14 kg	-6.0 in -0.15 m	-1.8 in lb -0.02 m kg	166 in 4.22 m	49.8 in lb 0.60 m kg
D412-705-023 Oil Cooler Support Removable Lower Panel Kit (net)	0.2 lb 0.09 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	47.6 in lb 0.55 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-041	ACCESS PANEL ASSEMBLY
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
		44	36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
		22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

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Revision: B

Date: 04.09.27